

# Work Order ID 65934

Thursday, January 27, 2011 1:07:47 PM



Page 1

Item ID:	D4017-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Base Assembly (350 )					
Start Date:	1/28/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/14/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>1-01-27</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4017	C

100	Weld per dwg A/R S.S. rod Batch: <u>1114649</u>	0.00							
	Large Fab								
Large Fab									
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D4017 using DT9610B ***inspect before welding mesh*** 2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D4017 ***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							

Pl 11-02-10

11/02/10 (K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 65934**

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Setup Start

Revision ID:

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Item Name: Short Basket Base Assembly (350 )

Start Date: 1/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

Eulozh1



QC

Memo

0.00

Quality Control

(X)

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-02-14

W/O:		WORK ORDER CHANGES					
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[illegible]

Thursday, January 27, 2011 1:07:47 PM

**Accept**

[illegible]**Setup Start**

[REDACTED]

**Stop**

\_\_\_\_\_

**Cust Item ID:**

**Customer:**

Run Start

[REDACTED]

**Stop**

[illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

[illegible]

## Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME: 9:23

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

*EF 511/02/14 @*

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sulorly**AD*

170

Identify as per dwg & Stock Location *GA*

0.00



Packaging

Memo

0.00

Packaging

*W/O 65942**EF 511/02/14 @*

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/02/15

PL 11-02-14

V

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, January 27, 2011 1:07:43 PM

Page 1

Work Order ID: 65934

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4017-1 Rib		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
					65385			3					
✓ D4017-3 Rib		Manufactured	No			100	Each	0.0000	1	1			
								B65905					
D4017-5 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1			
✓								B65914					
D4017-7 Rib		Manufactured	No			100	Each	8.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					58929			2					
					64681			3					
					65850			3					

6.

SAD 11-02-07

SAD 11-02-07

SAD 11-02-07

SAD 11-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 65934

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

29.0000

2

2



Mounting Bracket



SAD 11-02-07

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

2

D3913-15

Manufactured No

100

Each

11.0000

1

1



Wide Handle Plate



SAD 11-02-07

Location

Loc Qty

Loc Code

WA

11

63627

1

64900

4

65851

6

1

D4016-1

Manufactured No

100

Each

10.0000

3

3



Hinge Half, Base



B65849 (3x) 11/02/10

Location

Loc Qty

Loc Code

WA

10

64264

1

65374

9

1

D4020-3

Manufactured No

100

Each

0.0000

1

1



Mesh (350 Basket Short, Base)



M B65907

SAD 11-02-07

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 65934

Parent Item: D4017-041



Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011



Start Qty: 1.00

Required Qty: 1.00

✓ D4020-11 Manufactured No 100 Each 8.0000 2 2  
  
 End Mesh, Basket  
 SAD 11-02-07



Location Loc Qty Loc Code

WA 8  
 59413 1  
 61306 1  
 64923 6

D2931 Manufactured No 150 Each 734.0000 2 2  
  
 Bumper  
 2  
2 2 2



Location Loc Qty Loc Code

ST504 734  
 46064 734

✓ D4021-1 Manufactured No 100 Each 27.0000 3 3  
  
 Handle Plate  
 46064  
3 3 3  
SAD 11-02-07

Location Loc Qty Loc Code

ST109 5  
 57086 5  
 WA 22  
 64136 1  
 64903 9  
 65848 12

D4021-5 Manufactured No 150 Each 8.0000 2 2  
  
 Blanking Plate  
 2  
2 2 2

Location Loc Qty Loc Code

ST112 8  
 64243 8

65678

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

Work Order ID: 65934

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No 150 Each 117.0000 6 6  
Bolt

Location	Loc Qty	Loc Code
ST351	117	
115877	1	
116075	16	
116400	100	

AN960JD8 *R* NAS1149DN832J Purchased No 150 Each 10.0000 2 2  
Washer

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

MS20600-AD4W3 Purchased No 150 Each 1,335.000 2 2  
Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1335	
107939	754	
111636	581	

MS21042L3 Purchased No 150 Each 3,053.000 6 6  
Nut

Location	Loc Qty	Loc Code
ST300	3053	
114784	9	
115835	544	
116391	900	
116540	800	
116549	800	

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Page 5

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Thursday, January 27, 2011 1:07:44 PM

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Work Order ID: 65934



Parent Item: D4017-041



Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

278.0000

12

12



WASHER

*Signature*

Location

Loc Qty

Loc Code

ST275

278

18057

278

18057

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

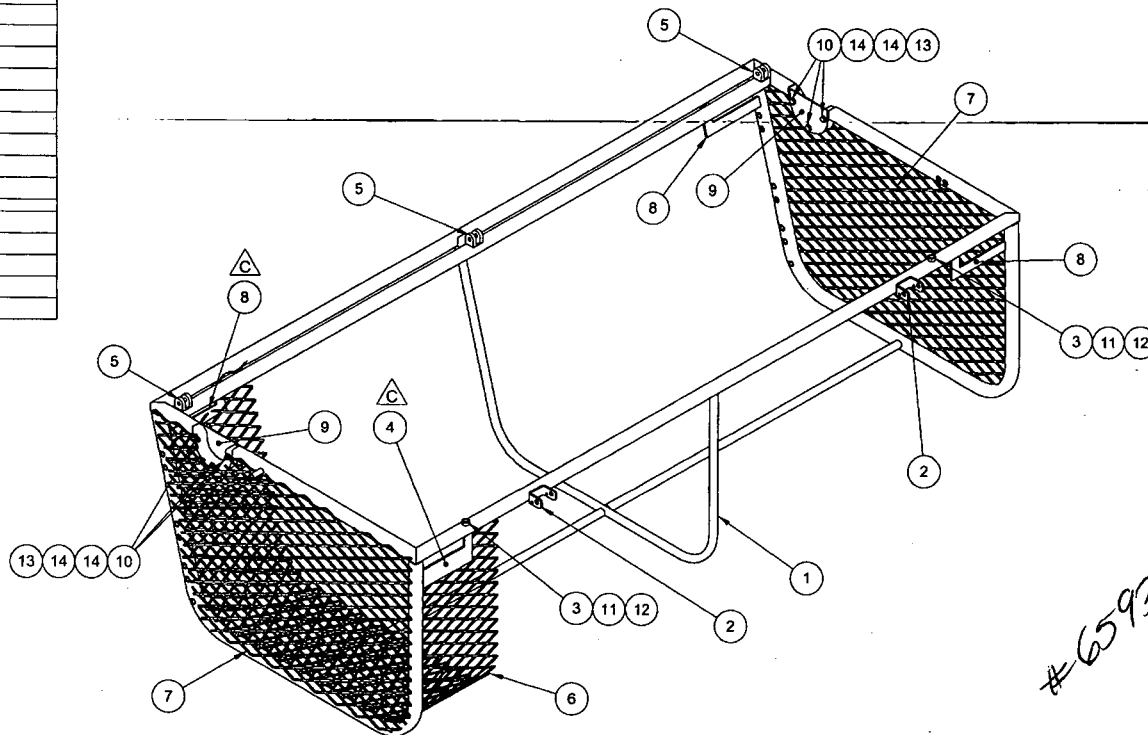
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

#65934

ECN 10-596  
**RELEASED**  
10.06.12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 28.8 lbs APPROX
  - 8) INSTALL AFTER FINISH
  - 9) MASK HOLES PRIOR TO POWDER COAT
  - 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	J.F.B.		
APPROVED			
DE APPR.			
DATE	10.07.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C  
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350)** SCALE NTS

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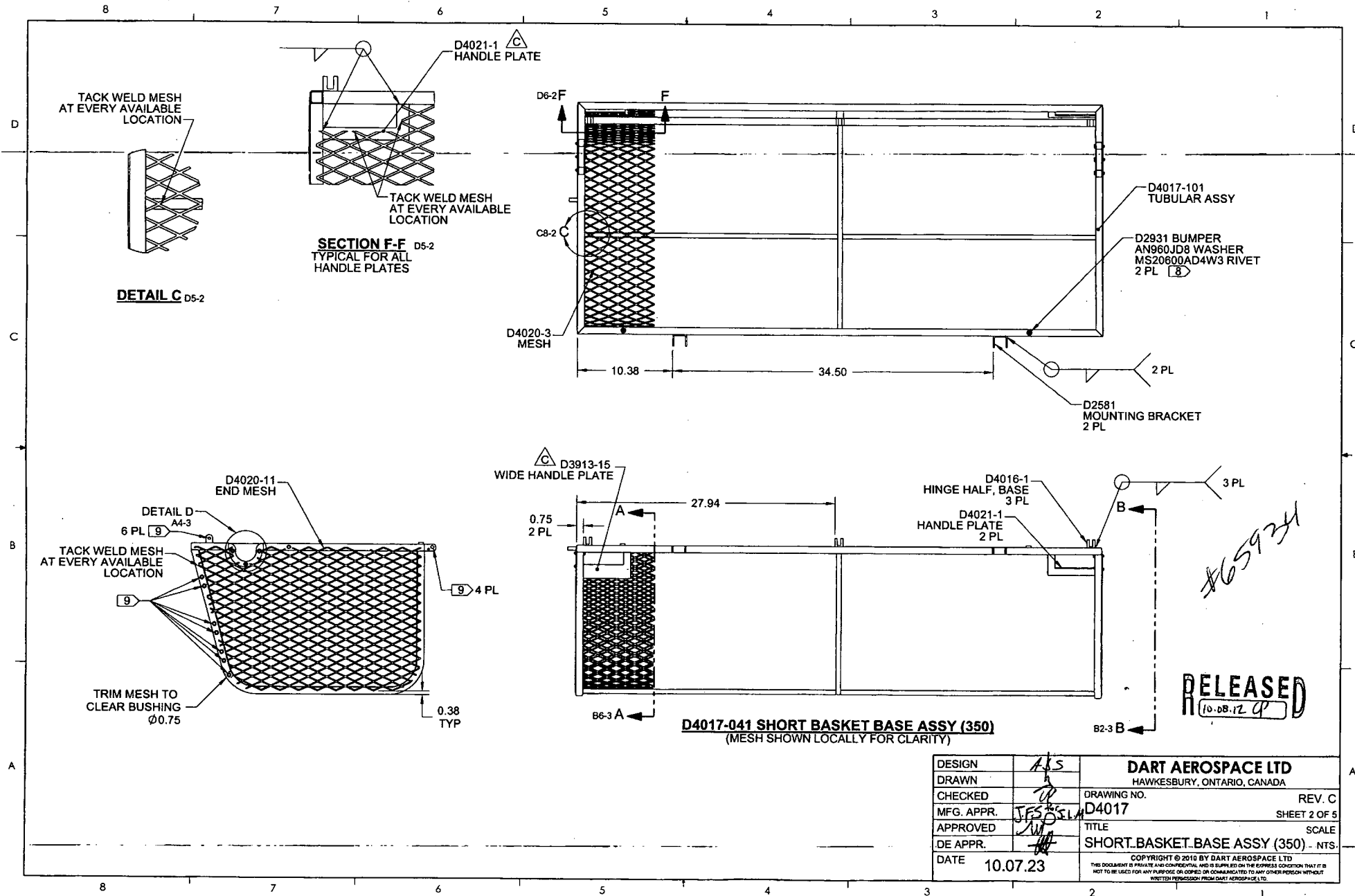
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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8 7 6 5 4 3 2 1

D

D

C

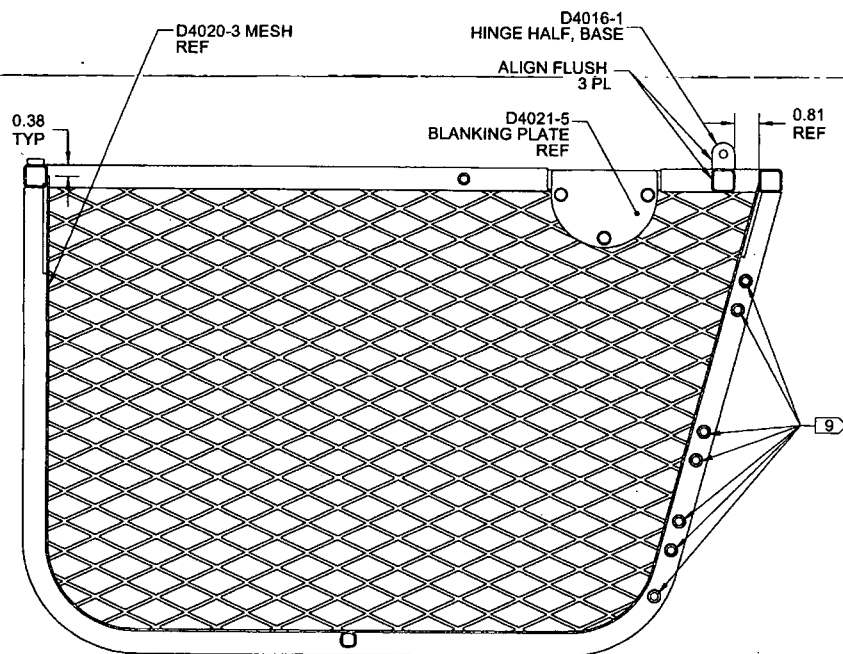
C

B

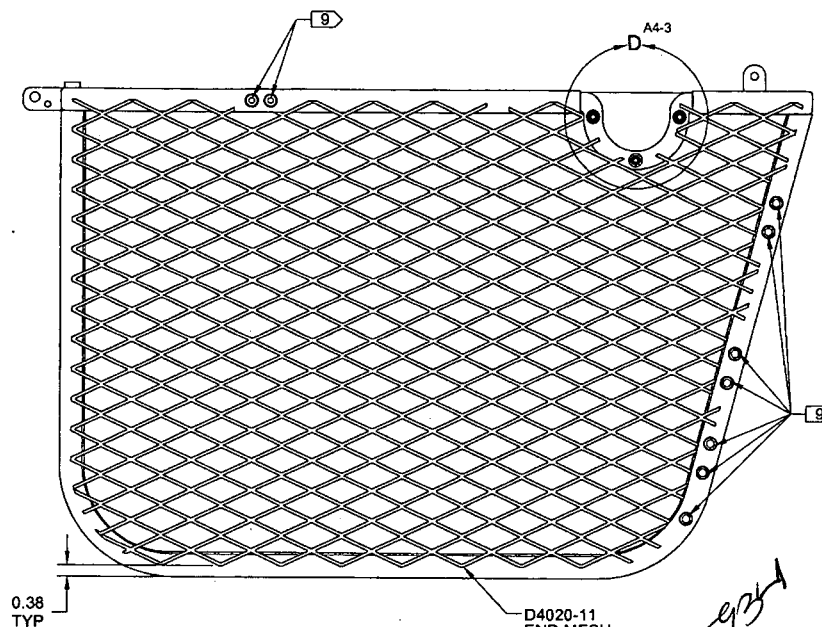
B

A

A



**SECTION A-A** A5-2



**SECTION B-B** A2-2

D4020-11  
END MESH

8  
D4021-5  
BLANKING PLATE

AN3-10A  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
3 PL

TRIM MESH LOCALLY  
Ø0.50 - Ø0.60  
TO CLEAR FASTENERS

**DETAIL D** D1-3  
B8-2

#65934

**RELEASED**  
10.08.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. <b>D4017</b>	REV. C
MFG. APPR.	JFS	SHEET 3 OF 5	
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	<b>SHORT-BASKET-BASE ASSY (350) -NTS</b>	
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

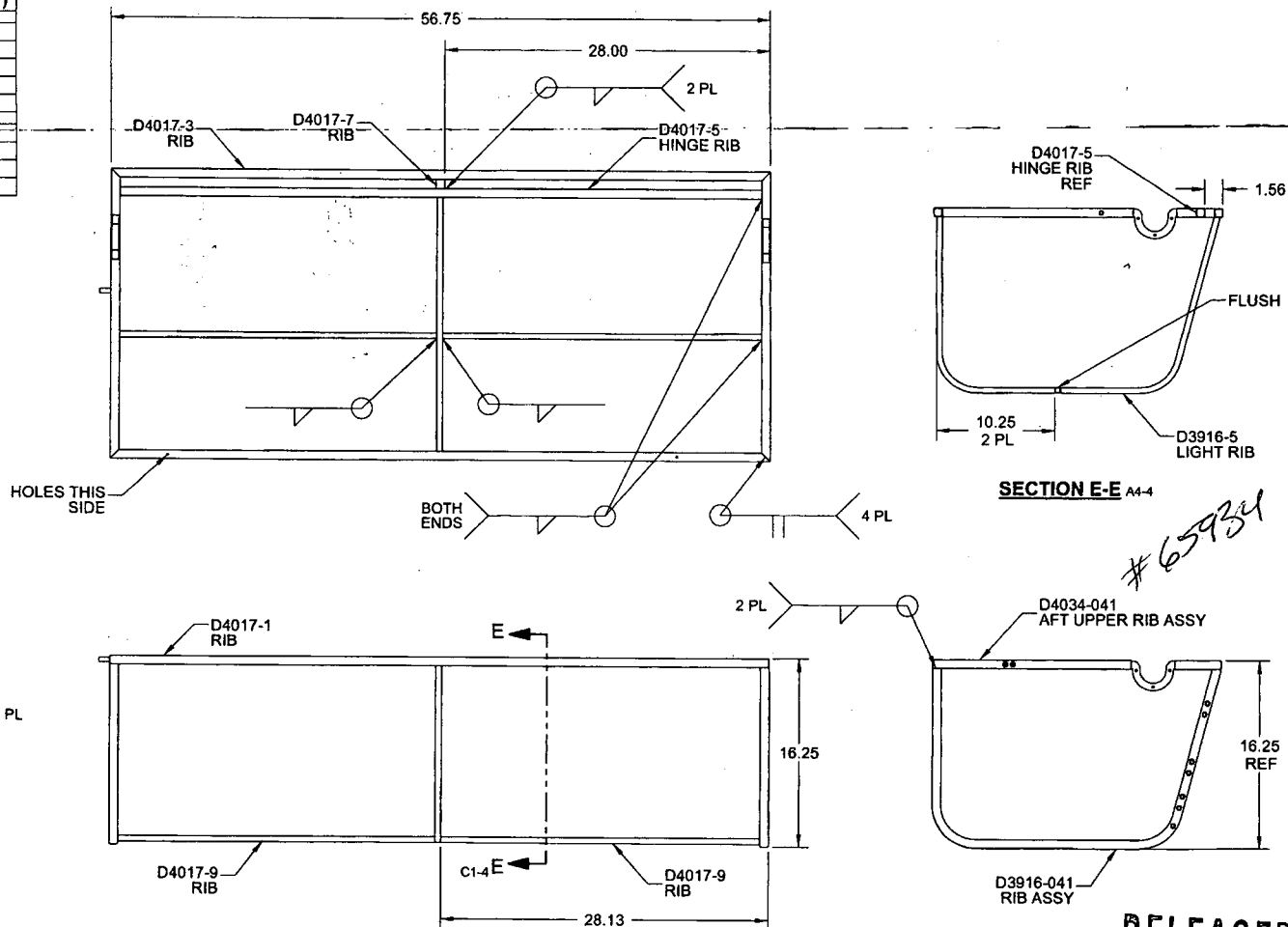
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 15.26 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
- 9) WELD PER DART QSI 004

## 8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO.	REV. C
MFG. APPR.	AKS	D4017	SHEET 4 OF 5
APPROVED	AKS	TITLE	SCALE
DE APPR.	AKS	SHORT BASKET-BASE-ASSY (350)	NTS
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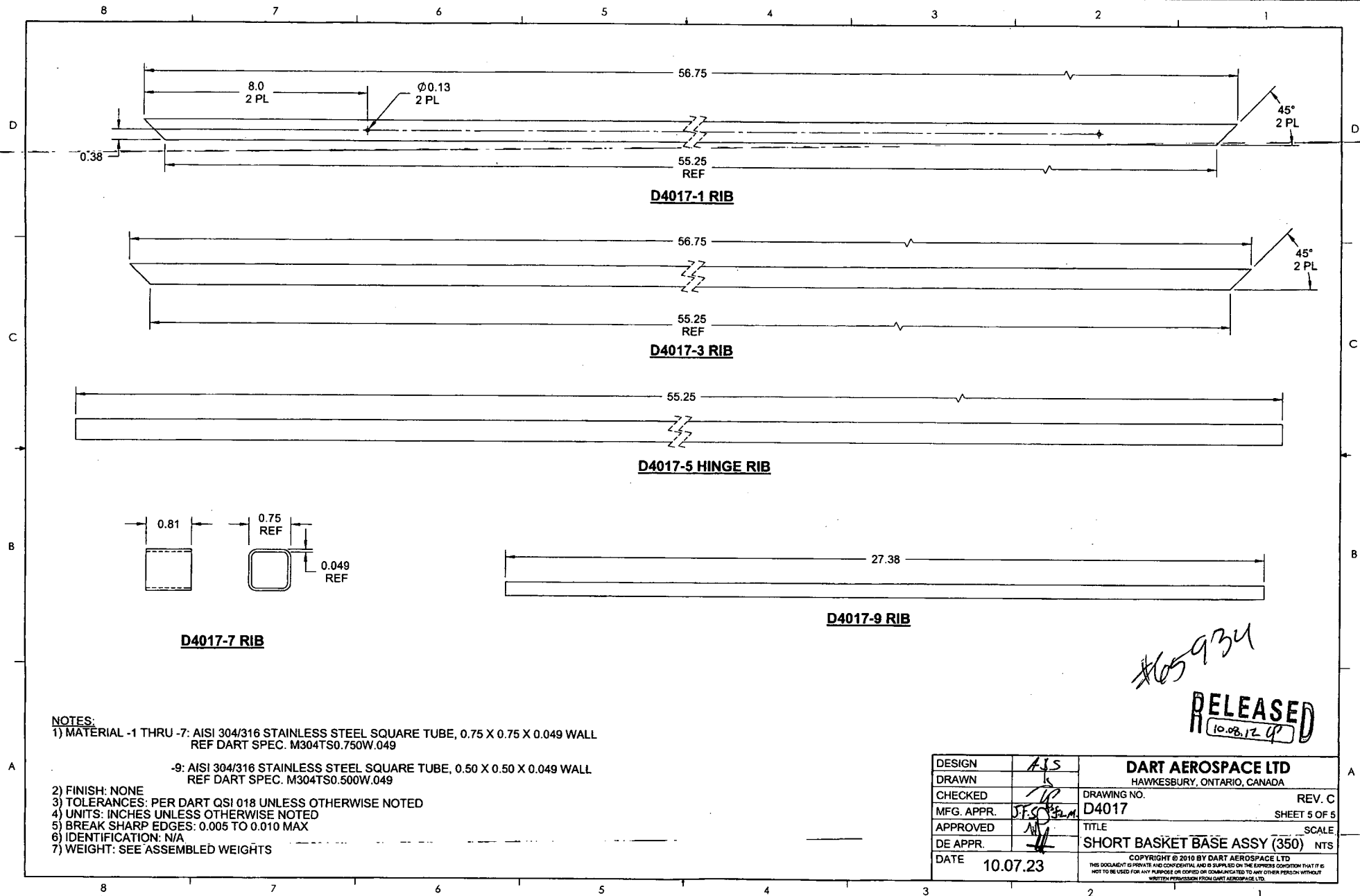
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



*#65934*

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10.08.12.97

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries